

Work Order ID 84370

May-10-12 2:35:14 PM

84370

Page 1

Item ID: D4062-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4062	C					(4)			
100		0.00							
100									
Waterjet		0.00							
FLOW CNC Waterjet									
UHMW .250									
	Memo								
	CUT AS PER FILE D4062-3								
	dwg rev:								
	prog rev: C								
102	QC2- Inspect parts off machine FAI/FAIB	0.00							
102									
QC		0.00							
Quality Control	Memo								
130	QC8- Inspect parts - second check	0.00							
130									
QC		0.00							
Quality Control	Memo								

B12-5-20

B12-5-20

5.7/0112

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84370

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 Identify as per dwg & Stock Location: WA 0.00***140***

Packaging Memo 0.00

Packaging

150 QC21- Final Inspection - Work Order Release 0.00

150

QC Memo 0.00

Quality Control

4x

SP
12-522

12/5/22

MF

12-05-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

May-10-12 2:35:18 PM

Page 1

Work Order ID: 84370

84370

Parent Item: D4062-3

D4062-3

Parent Item Name: Lower Tank Support

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-11-28 JLM VERIFIED BY:DD IPP
REV:B AS PER REV C 12-03-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB250

Purchased

No

sf

71.0000

11.36842

12.

MI IHMWB250

**

UHMWB .250 BLACK

12-5-20

Location

Loc Qty

Loc Code

MAT019

71

121064

71

12,064

④

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

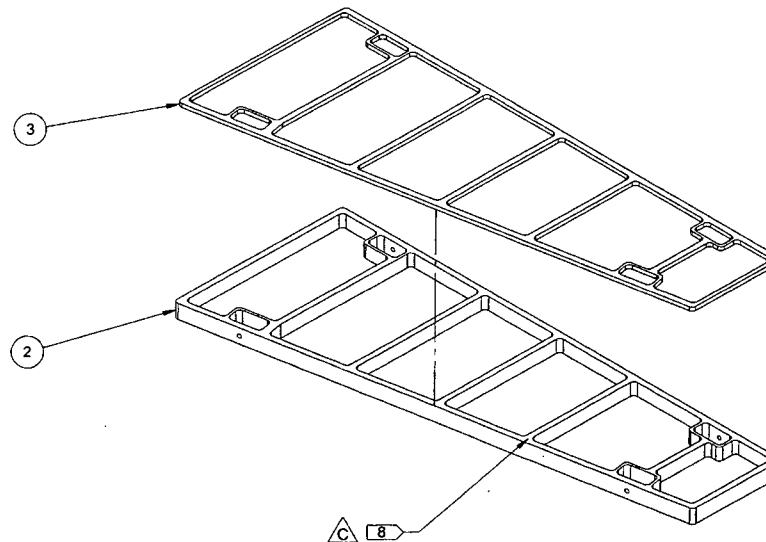
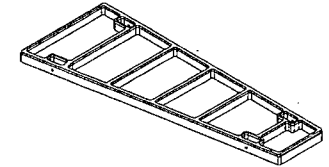
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4062-041	TANK SUPPORT ASSEMBLY
2	1	D4062-1	LOWER TANK SUPPORT
3	1	D4062-3	UPPER TANK SUPPORT



D4062-041 TANK SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.91 lbs
- 8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 84370 MLJ
12/05/11

11.12.14
11.09.29
10.07.26
11.12.14

C	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE C'BORE.	DC	11.12.14
B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4062	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TANK SUPPORT	NTS
DATE	11.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

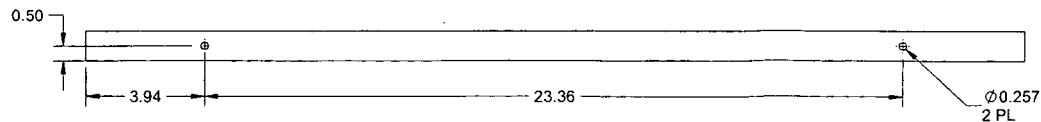
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

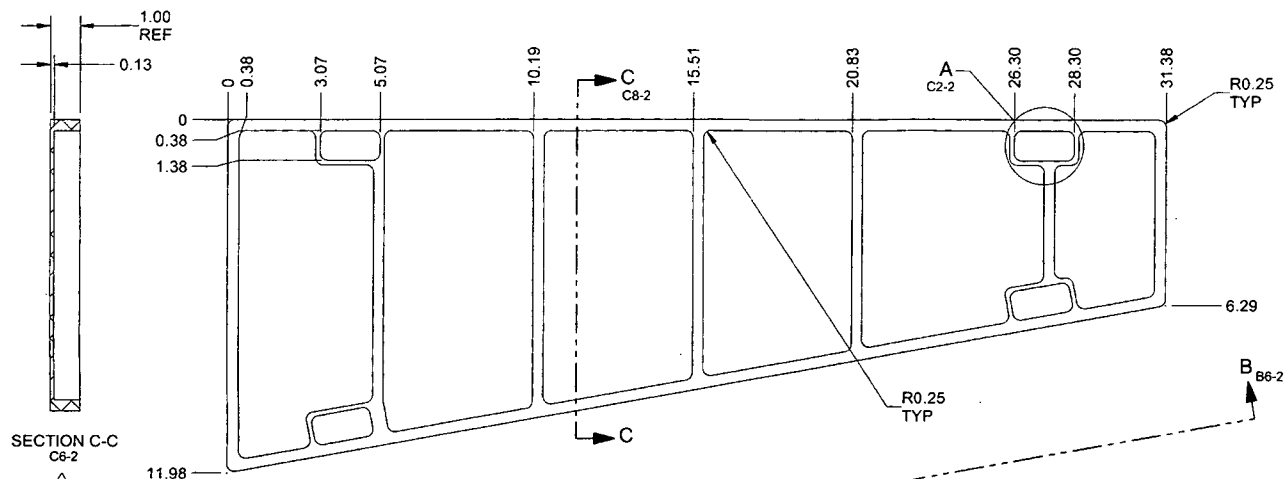
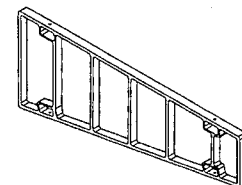
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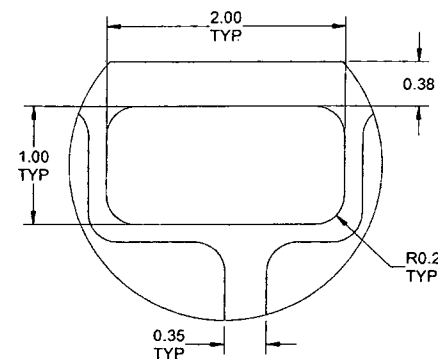
NOTE: Date & initial all entries



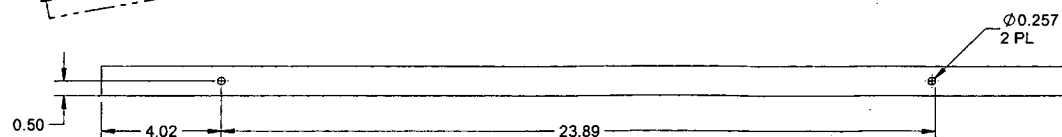
84370



SECTION C-C
C8-2



DETAIL A
SCALE 4X
C4-2



VIEW B-B
B5-2

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.53 lbs
- 8) CUT PER D4062-1.DXF
- 9) MAXIMUM INSIDE RADIUS = 0.250

D4062-1 LOWER TANK SUPPORT

DESIGN	AE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	AE	DRAWING NO. D4062	REV. C SHEET 2 OF 3
MFG. APPR.	AE	TITLE TANK SUPPORT SCALE NTS	
APPROVED	AE		
DE APPR.	AE	DATE 11.12.14	

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RELEASED
2012-03-02
JM

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

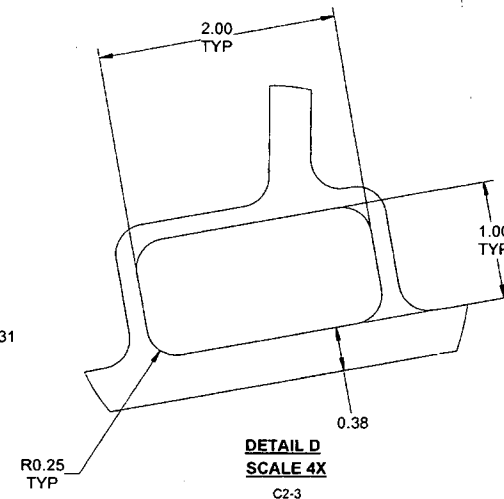
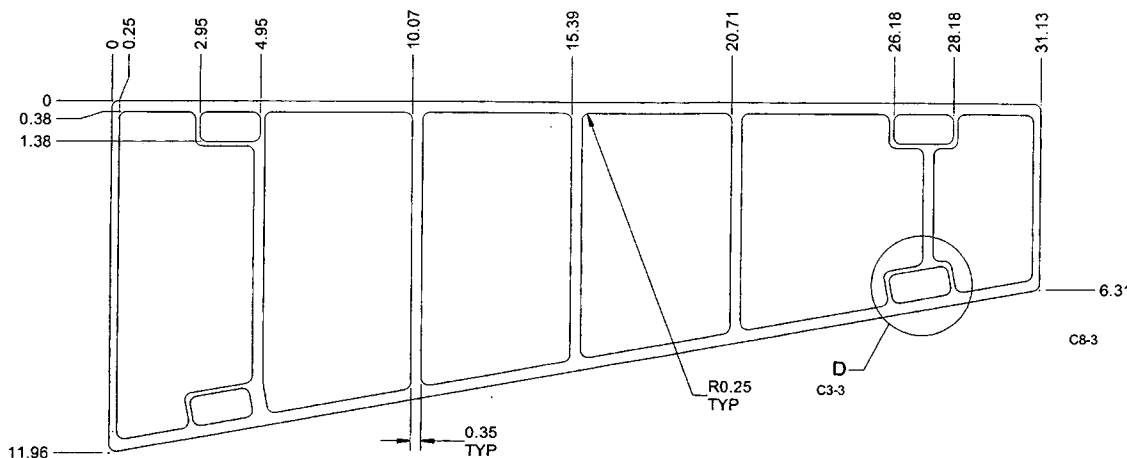
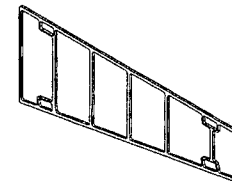
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84370



D4062-3 UPPER TANK SUPPORT

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.25 THICK
REF DART SPEC MUHMWB025
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) CUT PER D4062-3.DXF

RELEASED
2012-03-02

DESIGN	BE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	BE	D4062	SHEET 3 OF 3
APPROVED	149	TITLE	SCALE
DE APPR.	149	TANK SUPPORT	NTS
DATE	11.12.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 84370
Description: LOWER TANK SUPPORT		Part Number: D4062-3
Inspection Dwg: D4062-3 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.38	$\pm .020$.375	2		V R62	
1.00	$\pm .020$	1.005	2		V	
2.00	$\pm .020$	1.998	2		V	
.25	$\pm .020$.233	2		V	
2.95	$\pm .020$	2.941	2		V	
4.95	$\pm .020$	4.95	2		T FBL	
10.07	$\pm .020$	10.07			T	
15.39	$\pm .020$	15.39	2		T	
20.71	$\pm .020$	20.71			T	
26.18	$\pm .020$	26.18	2		T	
28.18	$\pm .020$	28.18	2		T	
31.13	$\pm .020$	31.13	2		T	
1.38	$\pm .020$	1.361	2		T	
11.96	$\pm .020$	11.933	2		T	
6.31	$\pm .020$	6.318	2		T	
.35	$\pm .020$.358	2		V	
.250	$\pm .010$.258	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-5-19	Date: 12/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	